	er ID 68698 il 20, 2011 8:25:42 AM												Page 1
Revision ID: Item Name:		y: 10.00 ty: 10.00		Accept		Item I]]]]]]]]		s	Setup	Start Stop		10 10 100 10 10 100 100
Approvals:	Process Plan:	H	Date: //SM-	Tooling: SPC (Y/N):			nte:		F	t un	Start Stop		
Sequence ID/ Work Center II	Operatio D Descripti			Set Up/ Run Hours	Too	ol ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr												
D3208	Rev A1												
Shear	SHEAR	Memo Cut blank: 2.	750" x 4.300"□ldentif	0.00 0.00 y for D3208-7	SB 11	losl	(0		(10)		·		
110 Small Fab Small Fab	Small Fab	Memo Drill and Fill	et D3208-7comer as p	0.00 0.00 er Dwg D3208□Identify as	D3208-7	JS 1	llos la	ð	(P)			
120 Brake NC	NC BRAK	E Memo		0.00	(À	((los/	(o	(P)				

Deburr D3208-7□Polish any marks on part within 01. of Dwg D3208

Brake NC

Dart Aerospace	e Lto	t
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W/O:			WO	RK ORDER CHANG	ES			
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQA:	Date: _	1
		solution:	i					
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCR)	· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	Description of NC	I	Corrective Action Section		Verification	Approval	Approval
DAIL	SILP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Order ID 68698

Wednesday, April 20, 2011 8:25:42 AM



Page 2

Item ID:

D3208-7

Accept

Setup Start

Stop

Revision ID:

Start Date:

Item Name: Filler

Required Date: 4/25/2011

4/20/2011 **Start Qty: 10.00**

Req'd Qty: 10.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: _____ Date: Tooling:

Date:

Run Start

Date:_____

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/

Work Center ID

130

Operation **Description**

QC5- Inspect part completeness to step on W/O

Run Hours 0.00

000 Duw/10

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Quality Control

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

Memo

0.00

150

HandFinish

Hand Finishing

140

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

W/O:			W	ORK ORDER CHANG	ES			,
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	R	lesolution:	Dispositio	on:	_ QA: N/C Clo	osed:	Date: _	
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NCR	3)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
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Work Order ID 68698

Wednesday, April 20, 2011 8:25:42 AM



Page 3

Item ID:

D3208-7

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 4/25/2011

Filler

4/20/2011

Start Qty: 10.00

Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Memo

Tooling:

Date:

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

0.00

0.00

Set Up/

Run Hours

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Run

Reject Insp. Number Stamp

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES					
DATE	STEP	PROCEDU	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:		PAR #:	Fault Category: _	- NN ,	NCR: Yes No	DQA:	Date:	
F	Resolution:		Disposition:		QA: N/C Closed	:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action		Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Desci Chief Eng		ign & Date	Section C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 20, 2011 8:25:48 AM

Work Order ID: 68698

Parent Item:

D3208-7

Parent Item Name: Filler



Start Date: 4/20/2011

Required Date: 4/25/2011

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: B□04.05.25□Material changed for Step 4□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	95.5000	0.0902	0.949474			
										Sp	Wast	/2	

2024-T3 .040 sheet

Location	Loc Qty	Loc Code	
MAT022	95.5		
112291	0.5		
112331	31		
113162	64		

Dart Aerospace I	Ltd
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	Re	esolution:	Disposit	ion:	QA: N/C C	osed:	Date:	
NCR:			WORK OR	DER NON-CONFORM	MANCE (NCF	R)		
DATE	STEP	Description of NC			ection B	Verifica		l Approval
	0.2.	Section A	In itial Chief Eng	Action Description Chief Eng	Sign 8	Section	C Chief Eng	QC Inspector
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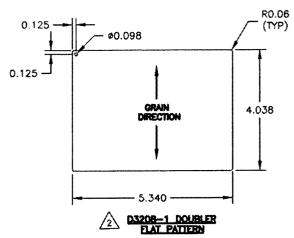


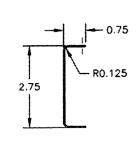


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	-4-		D3208	SHEET	1 OF 3
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04.01.27 NEW 155VE OF OIL US 25 CHANGE DIM ; NOTE 3) CHANGE







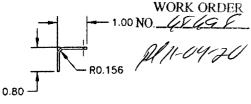
D3208-1 DOUBLER BEND DETAIL

SHOP COPY RETURN TO **ENGINEERING**

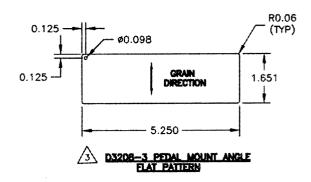
UNCONTROLLED COP

SUBJECT TO AMENDMENT

WITHOUT NOTICE



D3208-3 PEDAL MOUNT ANGLE BEND DETAIL



1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) ALL DIMENSIONS ARE IN INCHES 3) MATERIAL: 6061-TE (QR-A-250/H) 0.063" THICK (MGC61TES.063)

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Dart Aerospace Ltd

												
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DATE	STEP Description Section A	Description of NC	Corrective Action		Section B		Verification		Approval	Approval		
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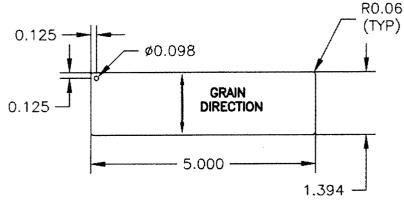
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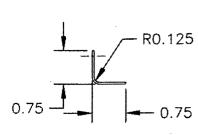




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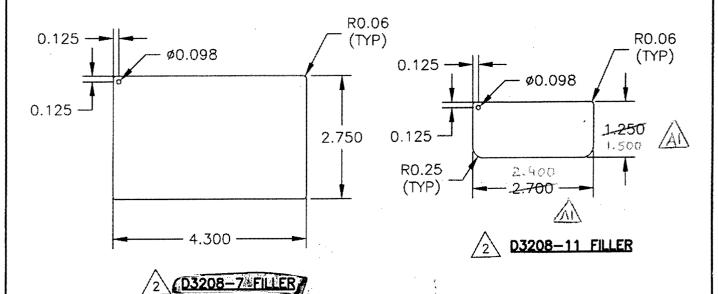




D3208-5 MOUNT ANGLE

D3208-5 MOUNT ANGLE BEND DETAIL

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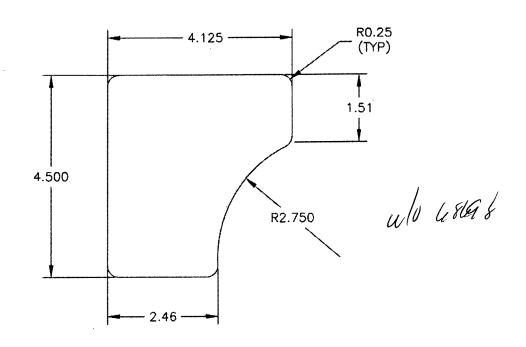
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D3208-9 DOUBLER

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